

Work Order ID 85040

85040

Page 1

May-31-12 3:38:20 PM

Item ID: D4544-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Retainer, Center

Stop ***NS2***

Start Date: 31/05/2012 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/10 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4544

100

Manufacture as per dwg

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

mill as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

115

0.00

115

Small Fab

Memo

0.00

Small Fab

FORM AS PER DWG

24 12-6-14
10 12-6-19

8/26/19

15

3

3

8/12/20

12-06-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 85040

May-31-12 3:38:20 PM

85040

Page 2

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Center

Start Date: 31/05/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

117

QC5- Inspect part completeness to step on W/O

0.00

117

QC

Memo

0.00

Quality Control

S. 12/6/21

test at 206 made up

(S)

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

5 7/6 12-6-21

130

QC7-Inspect Chemical Conversion Coat

0.00

130

QC

Memo

0.00

Quality Control

5 6 12-6-21

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NOTE: Date & initial all entries

Work Order ID 85040

May-31-12 3:38:20 PM

85040

Page 3

Item ID: D4544-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Center

Stop *NS2*

Start Date: 31/05/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

140

Identify as per dwg & Stock Location: 241 A 0.00

140

Packaging

Memo

0.00

5x

EP
12-6-21

Packaging

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Memo

0.00

12/6/22

Quality Control

MF
12-06-21

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

May-31-12 3:38:23 PM

Work Order ID: 85040

Parent Item: D4544-1

Parent Item Name: Retainer, Center

85040

D4544-1

Page 1

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP revA 12.01.17 new issue EC verified by:DD IPP
REV:B 12.02.24 as per dwg reva DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.250X02.00 0 | | Purchased | | No | | 100 | f | 45.0600 | 3.95 | 20.78947 | | | |

M6061T6B0 250X02 000

6061-T6 Bar .250 X 2.00

**

DR 12-6-14

Location

MAT001

107436 ✓

121836 ✓

Loc Qty

45.06

33.06

12

Loc Code

3.833
11.509

15-333

M122081

4f 12-6-19

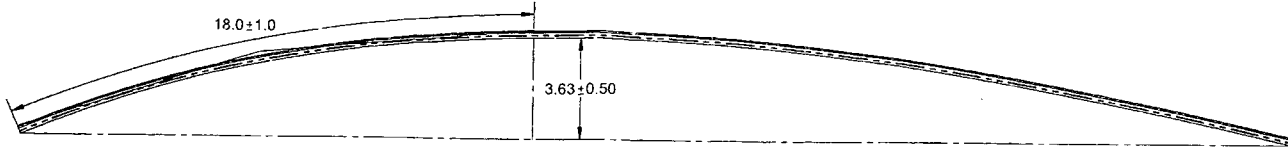
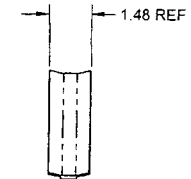
| W/O: | | WORK ORDER CHANGES | | | | | |
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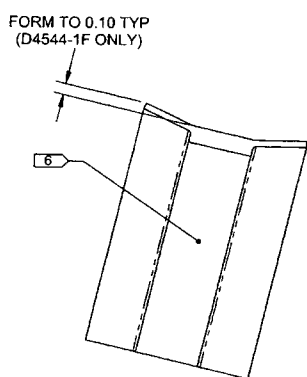
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4544-1 RETAINER, CENTER



VIEW A-A
SCALE 4X
CROPPED VIEW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85040 MLJ
12/06/01

RELEASED
2012-05-07

- NOTES:**
- 1) MATERIAL: MAKE FROM D4544-1F OR D4544-3-460
FLAT LENGTH = 46.00"
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4544-1" AND B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.61 lbs

| B | ADD -1F (WAS -1); ADD -3, -1 NOW BENT AND FORMED, R0.031 WAS R0.015 (BB-2) | CP | 12.04.20 |
|------------|--|----|----------|
| A | NEW ISSUE | CP | 12.01.09 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 12.04.20 | | |

| | |
|--|--------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D4544 | REV. B |
| TITLE RETAINER, CENTER | SHEET 1 OF 3 |
| SCALE NTS | |

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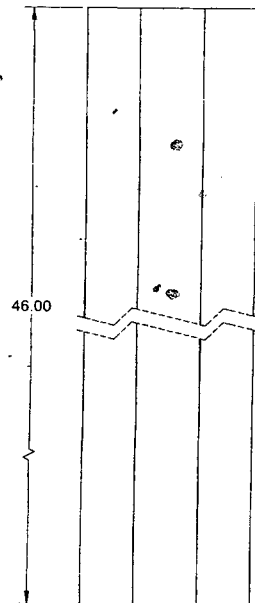
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

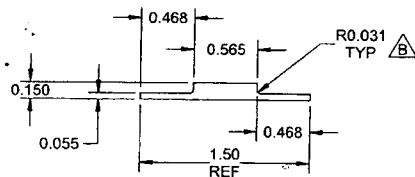
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



GRAIN
DIRECTION



D4544-1F RETAINER, CENTER

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET OR BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR QQ-A-250/11 OR AMS-QQ-A-250/11 (OR AMS 4025/4027)
OR ASTM B211 OR ASTM B221 OR ASTM B209
REF DART SPEC. M6061T6S OR M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.61 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4544 | REV. B |
| MFG. APPR. | | TITLE | SHEET 2 OF 3 |
| APPROVED | | RETAINER, CENTER | SCALE |
| DE APPR. | | | NTS |
| DATE | 12.04.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

RELEASED
2012-05-03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

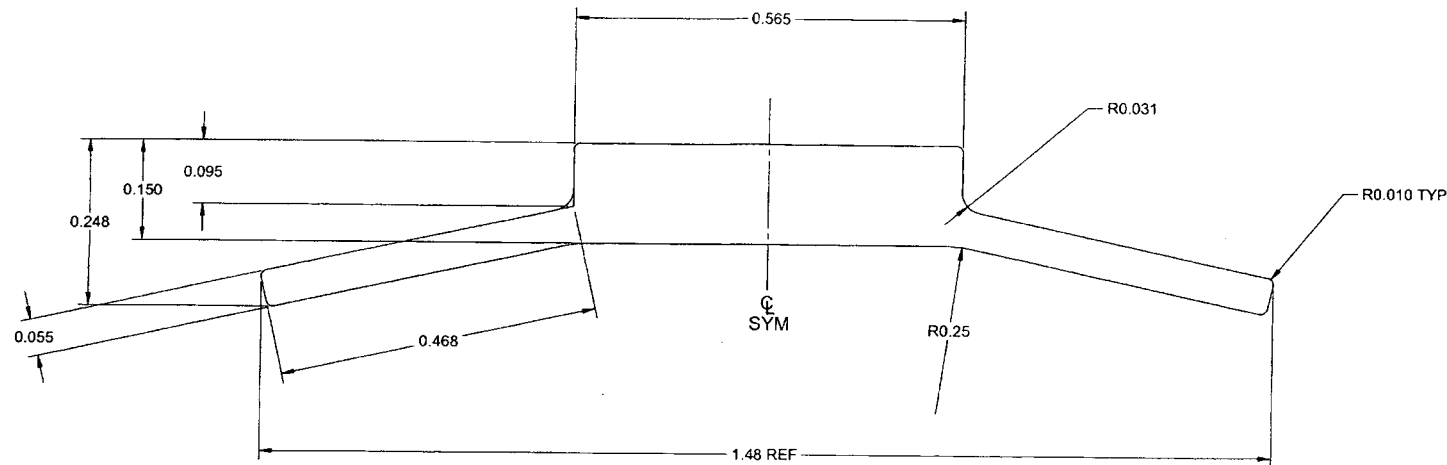
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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

8504D



D4544-3-XXX EXTRUSION

RELEASED
2012-05-07
LEASL
2012-05-07

NOTES:

1) D4544-3-XXX EXTRUSION

LENGTH

WHERE 'XXX' IS LENGTH IN TENTHS OF AN INCH
EG. 46" LONG EXTRUSION = D4544-3-460

- 2) MATERIAL: 6061-T6 ALUMINUM EXTRUSION PER
QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.0137 lb/in
- 8) NO TOOLING ID MARKS

| | | | |
|--|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | g | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. B |
| MFG. APPR. | | D4544 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | RETAINER, CENTER | NTS |
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